COLT .45 MACHINE PISTOL CONVERSION

SPECIFICATIONS:

CALIBRE ..... .45 ACP
TYPE OF FIRE ..... SELECTIVE SEMI AND FULL AUTOMATIC (FIRES SEMI AUTOMATIC ON CLOSED BOLT AND FULL AUTOMATIC ON OPEN BOLT.)
CAPACITY ..... 7 SHOT MAGAZINE STANDARD; 30 SHOT MAGAZINE AVAILABLE
BARREL LENGTH ..... 5 INCHES STANDARD; 6 INCHES AVAILABLE

REMARKS: NUMEROUS ACCESSORIES ARE AVAILABLE: MAXI COMPENSATORS, SLIDE RELEASES, TIGHT BUSHINGS, SPEED SAFETY, ETC.

SPECIAL NOTE: COLT .45 VARIATIONS AND IMITATIONS SUCH AS THOSE MANUFACTURED IN EUROPE, SOUTH, AND CENTRAL AMERICA CAN BE SIMILARLY CONVERTED TO SELECTIVE FIRE.

SYSTEM OF OPERATION:

TO FIRE SEMI AUTOMATIC: Set the selector lever to the horizontal position. To disengage the selector lock from the underside of the slide, press the top portion of the selector lever to withdraw its under lug from mating with the slide edge. Once the lug clears the slide edge, it can be rotated horizontally in either direction. Once the selector is set in detent in the horizontal position, the tripping of the selector is out of engagement with the connector lever. Drawing the slide to the rear will cock the hammer and load the chamber in the usual fashion, maintaining that position until the trigger is pressed. The semi automatic operation fires from the standard closed bolt system. *It is important to press the auxiliary trigger (front) at all times so that the front (auxiliary) sear does not catch the slide in open position.*

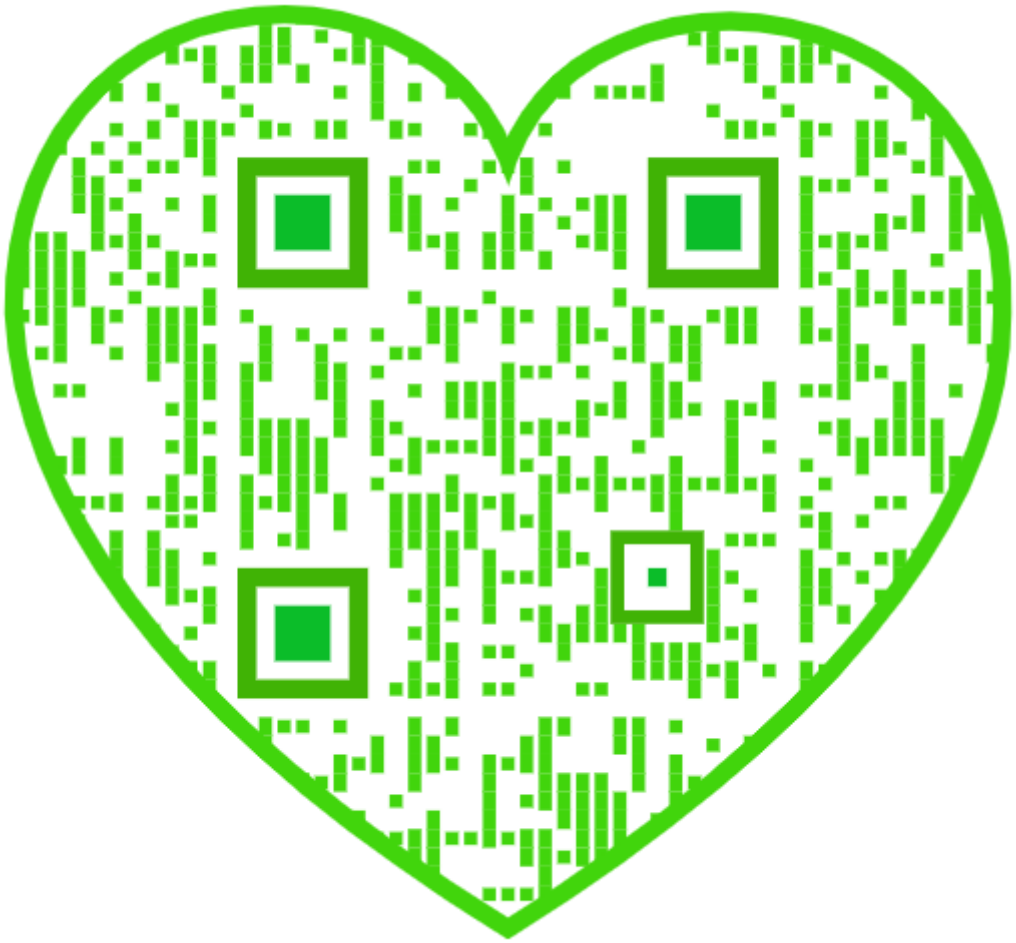
TO FIRE FULL AUTOMATIC: Set the selector lever to its position locking the under lug to the slide. The lug must mate with the edge of the slide as tightly as possible to avoid accidental disengagement during full automatic operation of the slide. The selector's detent spring must be strong to retain its engagement firmly in this position.

In the full automatic setting, the auxiliary trigger mechanism takes over. The slide will be held in the open bolt system by the front (auxiliary) sear, ready to fire. The original semi automatic trigger mechanism is activated automatically by the slide closing, once the selector tripping shoulder makes contact with the hammer sear connector, whether the rear (original) trigger is pressed or not. Once the selector lever tripping shoulder pushes the connector, the sear will disengage from full cocked hammer, releasing it to strike the firing pin and ignite the cartridge. This operation is continuous until the front trigger is released or the magazine empty.

CAUTION: *NEVER RETRACT THE SLIDE IF THE SELECTOR IS SET TO FULL AUTOMATIC WHEN THE GUN IS LOADED AND THE AUXILIARY TRIGGER MECHANISM IS NOT INSTALLED. THE WEAPON WILL FIRE FULL AUTOMATIC EVEN WITHOUT PRESSING THE TRIGGER SINCE THE SELECTOR TRIPPING SHOULDER WILL AUTOMATICALLY OPERATE THE CONNECTOR LEVER DURING BOLT CLOSING.*

SAFETY OPERATION:

The original safety can be used on both semi (closed bolt) and full automatic (open bolt) functioning. However, care must be taken that the auxiliary (front) trigger not be pressed if the selector is set to full



automatic and the slide is held open. The connector pin connected to the sear will break if the auxiliary trigger is pressed in open bolt with the selector in the full automatic mode.

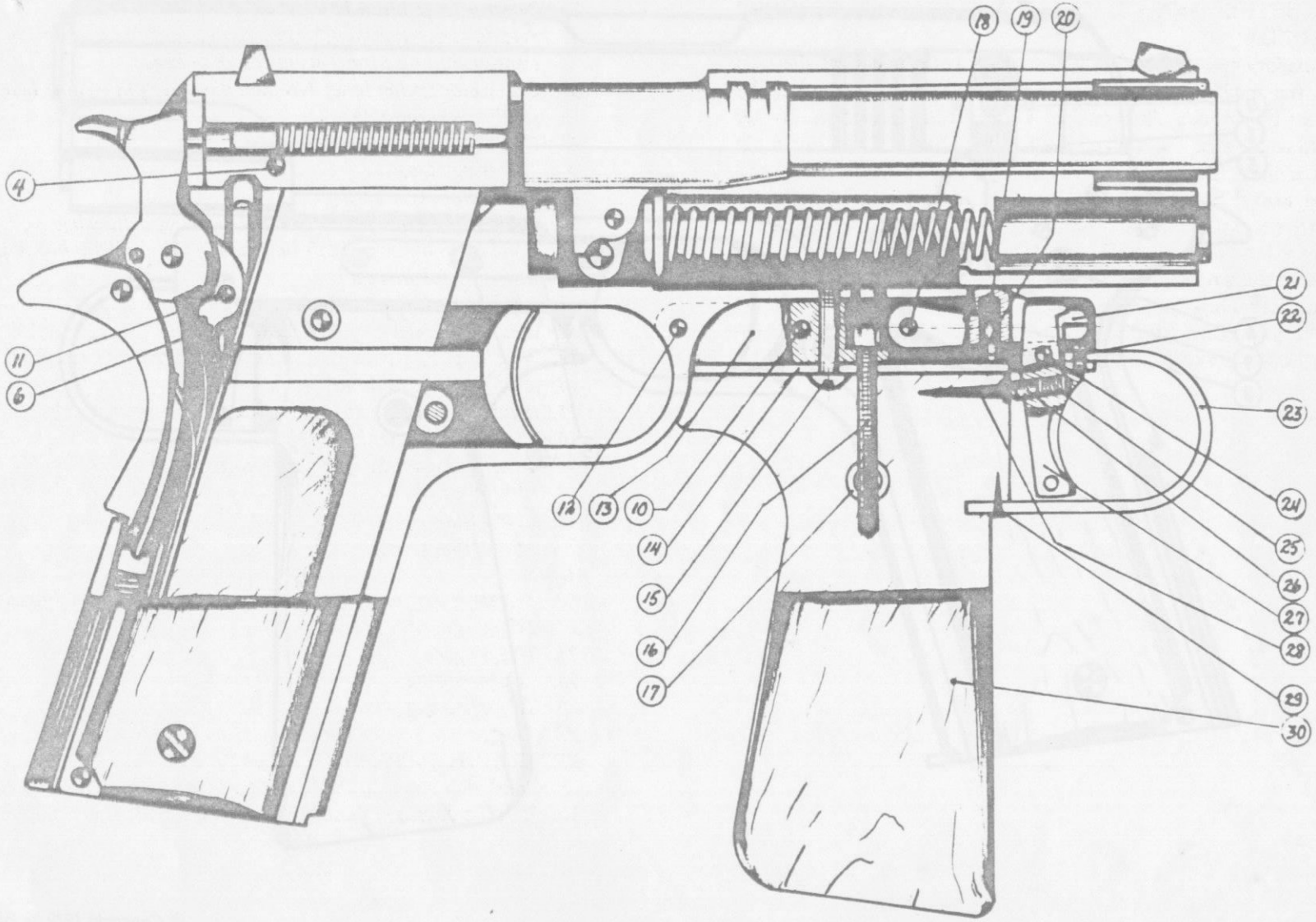
CONSTRUCTION DETAIL OF THE AUXILIARY TRIGGER MECHANISM:

The auxiliary trigger housing is a formed 1/16 inch steel sheet. It contains the auxiliary sear and trigger and can be improvised by machine or handmade. The housing is secured in place to the trigger guard and to the front portion of the receiver by a screw and by a pin riveted to a plate. An insert is used to strengthen the housing and can be riveted or brazed in place. The trigger guard is equal in width to the receiver trigger guard and secured to the housing by a small screw. It can be brazed to the housing if so desired. The other end is pointed and is pressed to the wood grip, secured by a small nail or screw.

The auxiliary housing assembly must be attached to the receiver body before the grip stock can be secured to the auxiliary housing. An assembly hole must be drilled in the receiver for the grip screw.

PARTS LIST

1. *Selector lever*
2. *Selector lever index ball spring*
3. *Selector lever index ball*
4. *Selector lever retaining screw; chambered for selector lug, upward clearance to disengage from the slide edge.*
5. *Connector spring base; 1/8 inch diameter pin – same height as the stock screw bushing.*
6. *Connector mating pin to sear*
7. *Connector lever*
8. *Connector lever spring*
9. *Connecting pins, plate for auxiliary trigger housing*
10. *Plate retaining screw; left side hole of the auxiliary housing must be threaded for this screw.*
11. *Replacement sear; with provision hole for connector mating pin*
12. *Auxiliary housing rear securing pin*
13. *Auxiliary trigger housing insert; to be brazed or riveted to housing*
14. *Auxiliary trigger housing*
15. *Auxiliary housing connecting screw to receiver body*
16. *Grip stock screw; hex type*
17. *Stock screw bushing; pressed horizontally to stock*
18. *Front sear pin*
19. *Sear spring*
20. *Sear spring plunger*
21. *Sear*
22. *Trigger guard connecting screw; guard can also be brazed in place*
23. *Trigger guard*
24. *Trigger pin*
25. *Trigger spring*
26. *Trigger spring plunger*
27. *Trigger*
28. *Nail; acts as support against plunger*
29. *Small nail securing the bottom part of trigger guard to stock*
30. *Wood stock; one piece construction (plastic is adaptable)*



COLT .45 MACHINE PISTOL CONVERSION

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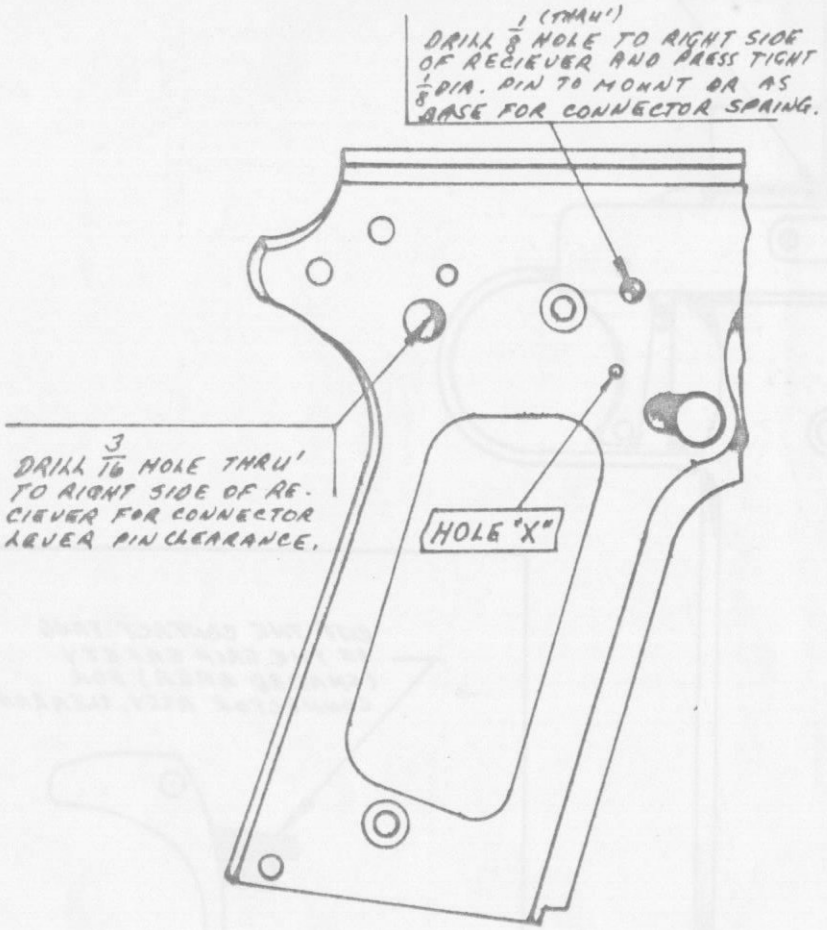
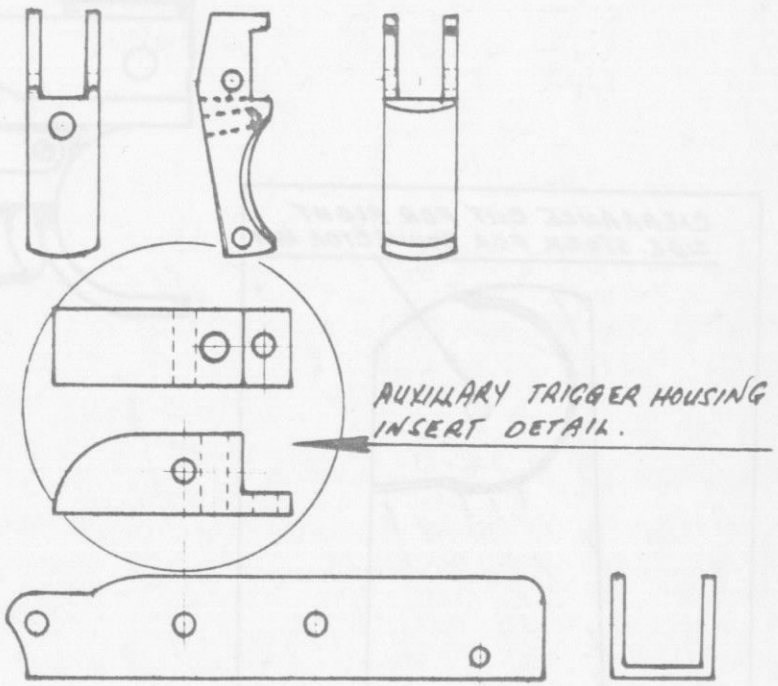
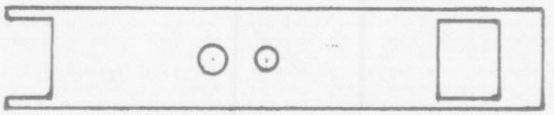

1/8 (THRU')
DRILL 1/8 HOLE TO RIGHT SIDE OF RECIEVER AND PRESS TIGHT 1/8 DIA. PIN TO MOUNT OR AS BASE FOR CONNECTOR SPRING.
3/16
DRILL 3/16 HOLE THRU' TO RIGHT SIDE OF RECIEVER FOR CONNECTOR LEVER PIN CLEARANCE.
HOLE "X"

DETAIL: "AUXILLARY TRIGGER"



AUXILLARY TRIGGER HOUSING DETAIL.



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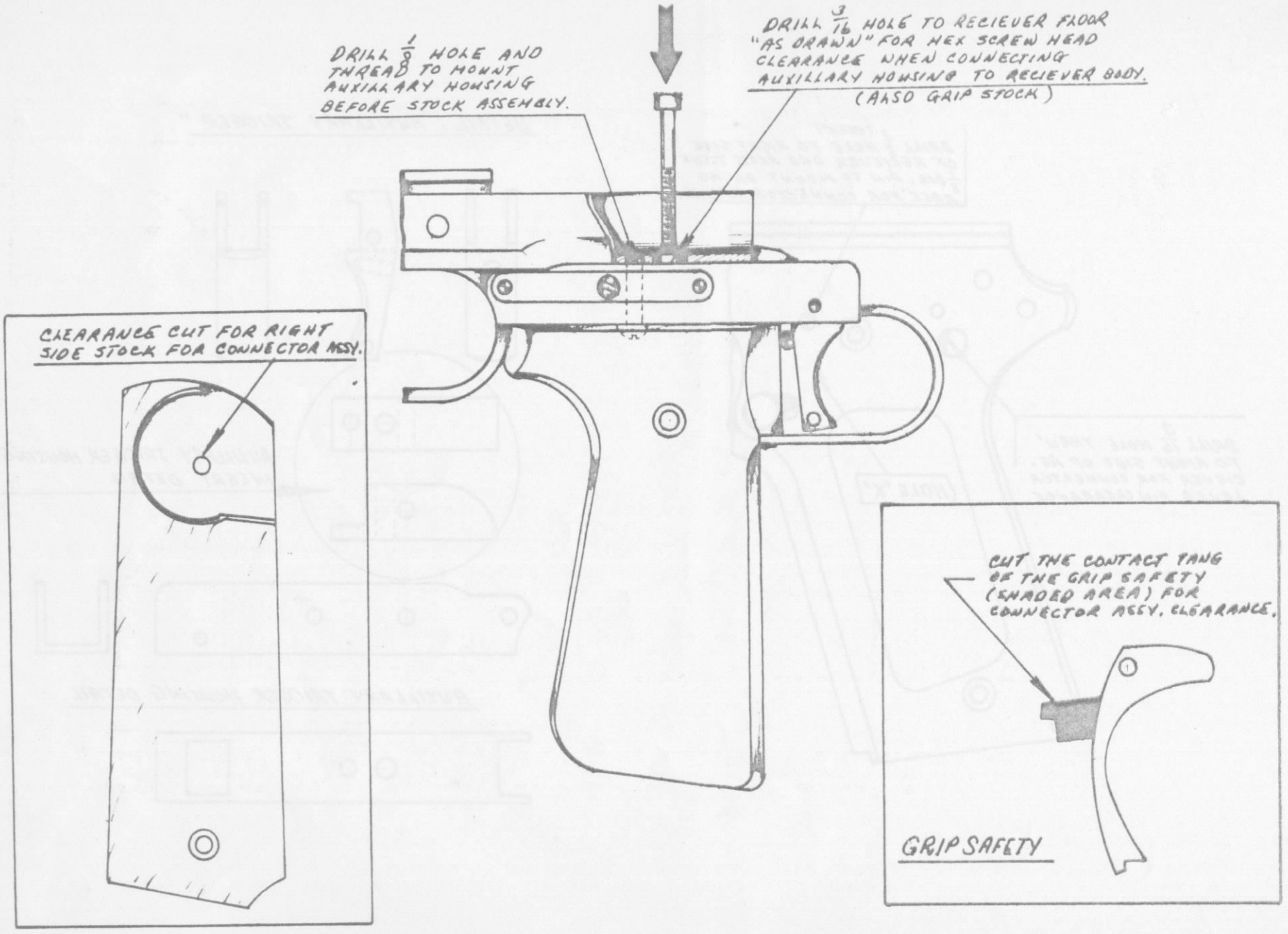
DRILL 1/8 HOLE AND THREAD TO MOUNT AUXILLARY HOUSING BEFORE STOCK ASSEMBLY.
DRILL 3/16 HOLE TO RECIEVER FLOOR "AS DRAWN" FOR HEX SCREW HEAD CLEARANCE WHEN CONNECTING AUXILLARY HOUSING TO RECIEVER BODY. (ALSO GRIP STOCK)
CLEARANCE CUT FOR RIGHT SIDE STOCK FOR CONNECTOR ASSY.
CUT THE CONTACT TANG OF THE GRIP SAFETY (SHADED AREA) FOR CONNECTOR ASSY. CLEARANCE.
GRIP SAFETY

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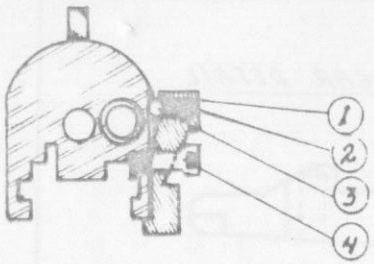
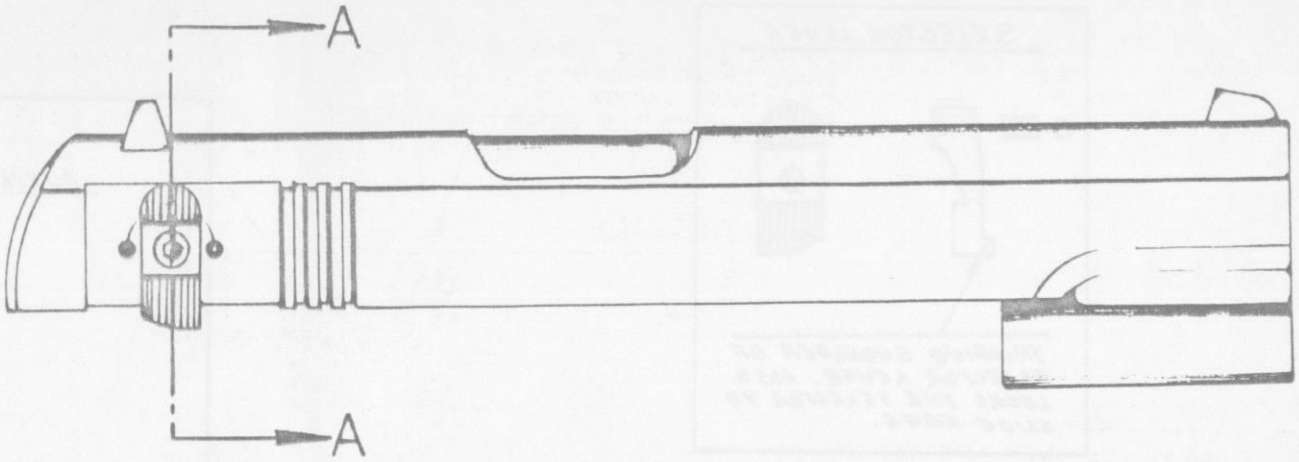
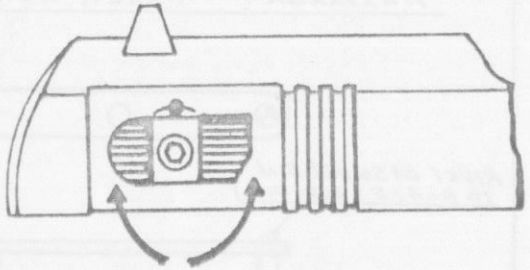
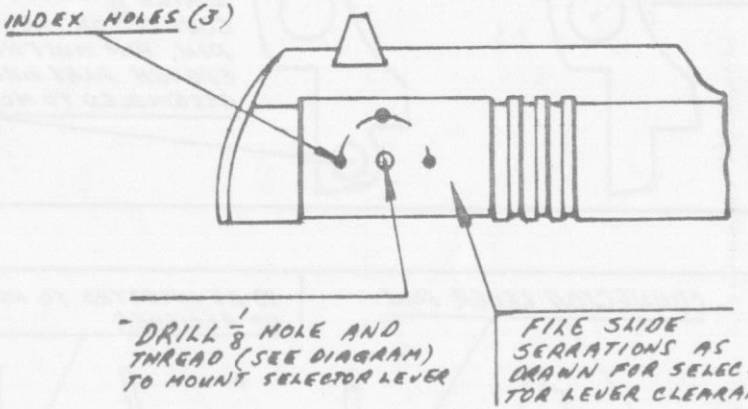


Section "AA"





SELECTOR CAN BE ROTATED ON EITHER WAY FOR SEMI-AUTO. FUNCTIONING. TRIPPING SHOULDER WILL NOT ENGAGE CONNECTOR TIP.


INDEX HOLES (3)
DRILL 1/8 HOLE AND THREAD (SEE DIAGRAM) TO MOUNT SELECTOR LEVER
FILE SLIDE SERRATIONS AS DRAWN FOR SELECTOR LEVER CLEARANCE.

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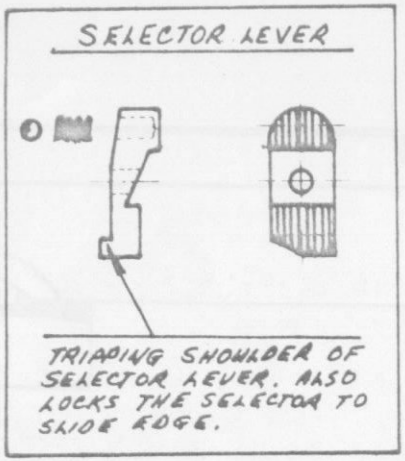
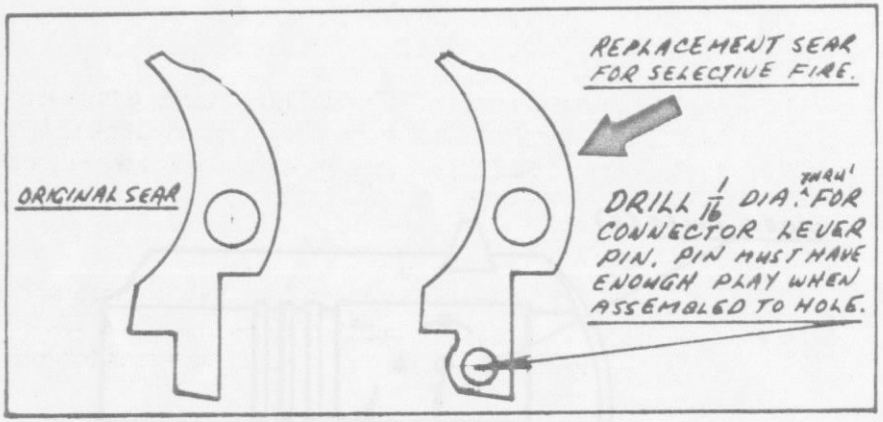
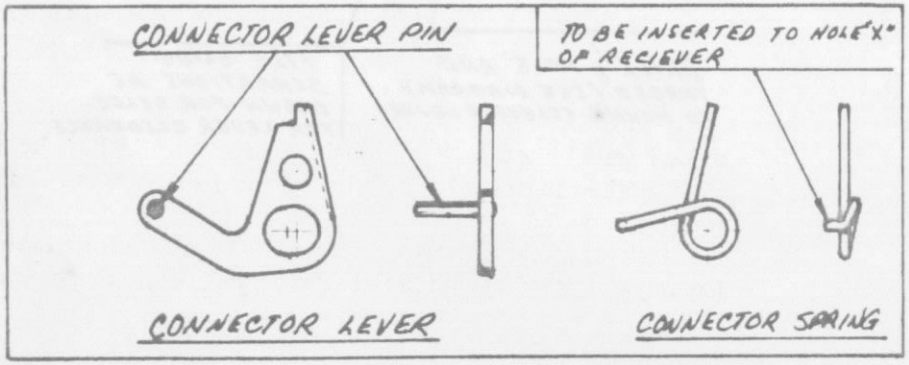
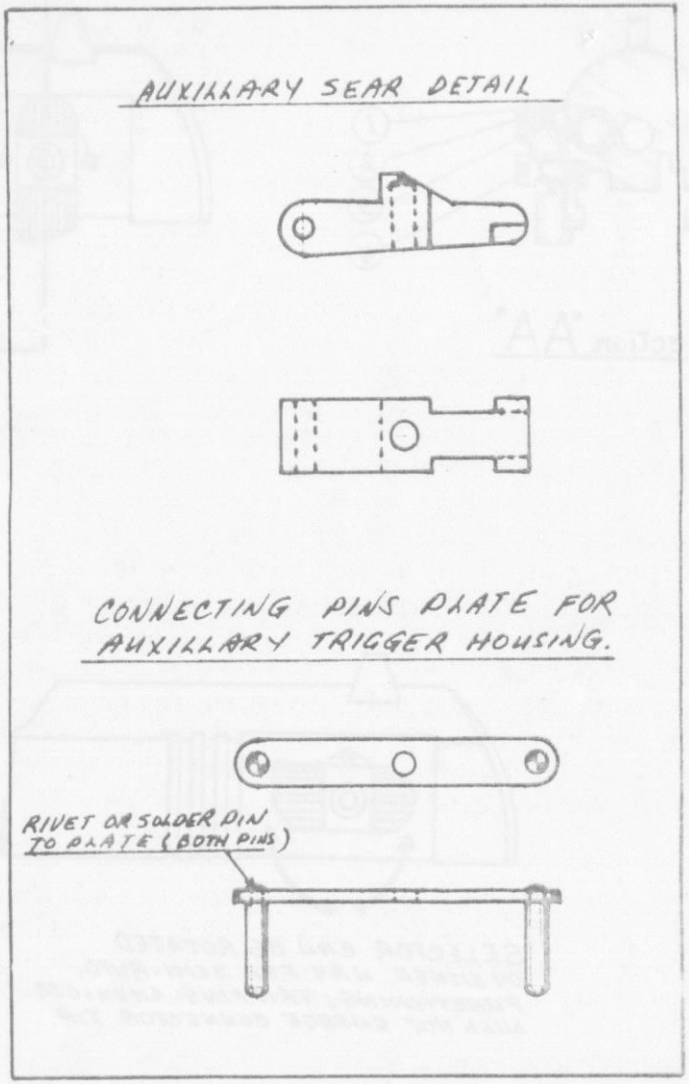



REPLACEMENT SEAR FOR SELECTIVE FIRE.
ORIGINAL SEAR
DRILL 1/16 DIA. THRU FOR CONNECTOR LEVER PIN. PIN MUST HAVE ENOUGH PLAY WHEN ASSEMBLED TO HOLE.





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